

Work Order ID 141169

January 29, 2016 1:26:49 PM

141169

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To ship Feb 26

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Rotor Pedal Lock
 Start Date: 1/29/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 2/19/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: SdH Date: 20160129 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120

0.00

120

Small Fab

Small Fab

Memo

0.07

Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>17132222</u>

17132222

3 FF FEB 12 2016

130

0.00

130

Small Fab

Small Fab

Memo

0.03

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-045

3 FF FEB 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐				

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐							

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Required Date: 2/19/2016 Req'd Qty: 3.00 *3* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

170

QC	Memo	0.01							
----	------	------	--	--	--	--	--	--	--

Quality Control

MC5 FEB 2 5 2016

MC5 FEB 2 5 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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		OTHER : ☐							

Picklist Print

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Work Order ID: 141169

Parent Item: D3371-041

Parent Item Name: Tail Rotor Pedal Lock

141169

D3371-041

Start Date: 1/29/2016

Required Date: 2/19/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-028		Purchased	No			120	Each	74.0000	2	6			
238-028									**		FF	FEB 24 2016	
3/16" Dowel Pin .5" long													

Location	Loc Qty	Loc Code
GA	9	
M103114	9	
ST568	65	
M132062	65	

AN526C832R6		Purchased	No			120	Each	32.0000	4	12			
AN526C832R6									**		FF	FEB 24 2016	
Screw													

Location	Loc Qty	Loc Code
GA	32	
m131379	32	

D2728-7		Manufactured	Yes			120	Each	0.0000	1	3			
D2728-7									**		FF	FEB 24 2016	
Dart Logo Label													

D3371-1		Manufactured	No			120	Each	1.0000	1	3			
D3371-1									**		FF	FEB 24 2016	
Pedal Lock Base													

Location	Loc Qty	Loc Code
ST498	1	
13391	1	

2
1

Picklist Print

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Work Order ID: 141169

Parent Item: D3371-041

Parent Item Name: Tail Rotor Pedal Lock

141169

D3371-041

Start Date: 1/29/2016

Required Date: 2/19/2016

Start Qty: 3.00

Required Qty: 3.00

D3371-3 Manufactured No

120 Each 3.0000 1 3

D3371-3

Pedal Lock Cover

**

FF

FEB 24 2016

Location

Loc Qty

Loc Code

ST498

3

139029

3

3

D3373-7 Manufactured No

120 Each 11.0000 1 3

D3373-7

Cam Lock

**

FF

FEB 24 2016

Location

Loc Qty

Loc Code

GA

5

101874

5

3

ST033

6

94791

6

D3385-3 Manufactured No

120 Each 19.0000 1 3

D3385-3

Hinge

**

FF

FEB 24 2016

Location

Loc Qty

Loc Code

ST034

19

117534

19

3

CBL-1240 Purchased No

130 f 479.8303 1.6666 5.262947

CBI-1240

Cable

**

FF

FEB 24 2016

Location

Loc Qty

Loc Code

GA

M130035

479.83026

m132518

479.83026

5.262947

Picklist Print

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Work Order ID: 141169

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Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 1/29/2016

Required Date: 2/19/2016

Start Qty: 3.00

Required Qty: 3.00

CBL-460

Purchased

No

130

Each

204.0000

2

6

CBL-460

Loop Sleeve

FF

FEB 24 2016

Location

Loc Qty

Loc Code

GA

204

m131619

5

m132518

16

m133344

10

m133786

5

m133875

68

m133985

100

D3384-1

Manufactured

No

130

Each

4.0000

1

3

D3384-1

Cyclic Sock

FF

Location

Loc Qty

Loc Code

ST500

12313

4

140040

4

B141455

①, B141398①

HX-81

Purchased

No

140

Each

47.0000

1

3

HX-81

1/4"-20 SHCS 3/8" long

FF

FEB 24 2016

Location

Loc Qty

Loc Code

ST563

47

123436

47

3

Picklist Print

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Work Order ID: 141169

141169

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 1/29/2016

Required Date: 2/19/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149F0463P

Purchased

No

140

Each

1,006.000

2

6

NAS1149F0463P

FEB 24 2016

Washer

Location

Loc Qty

Loc Code

ST260a

959

ST 262 m127832

959

st268

47

m127832

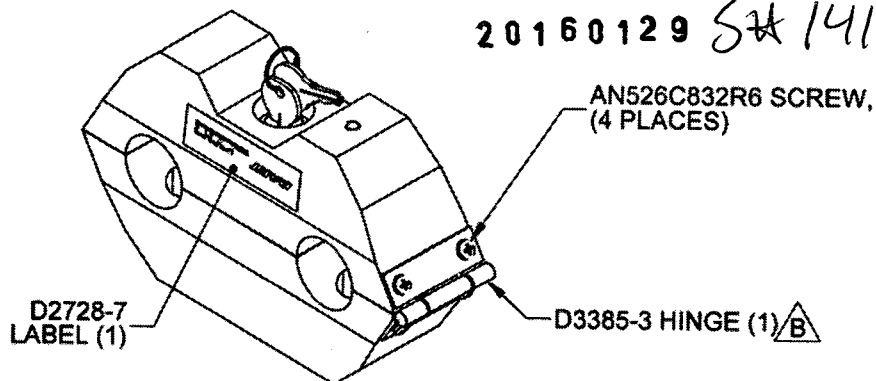
39

m130388

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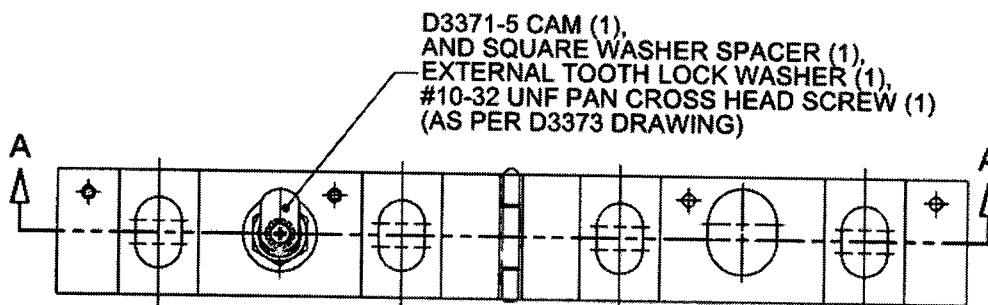
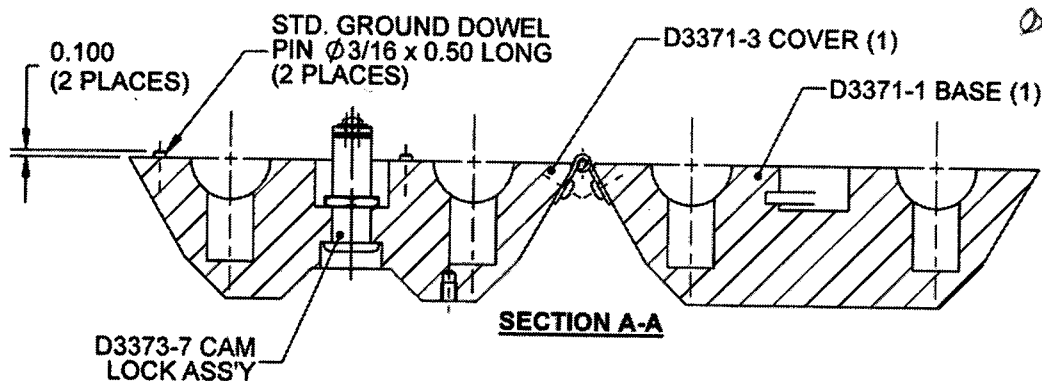


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
05/04/28



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

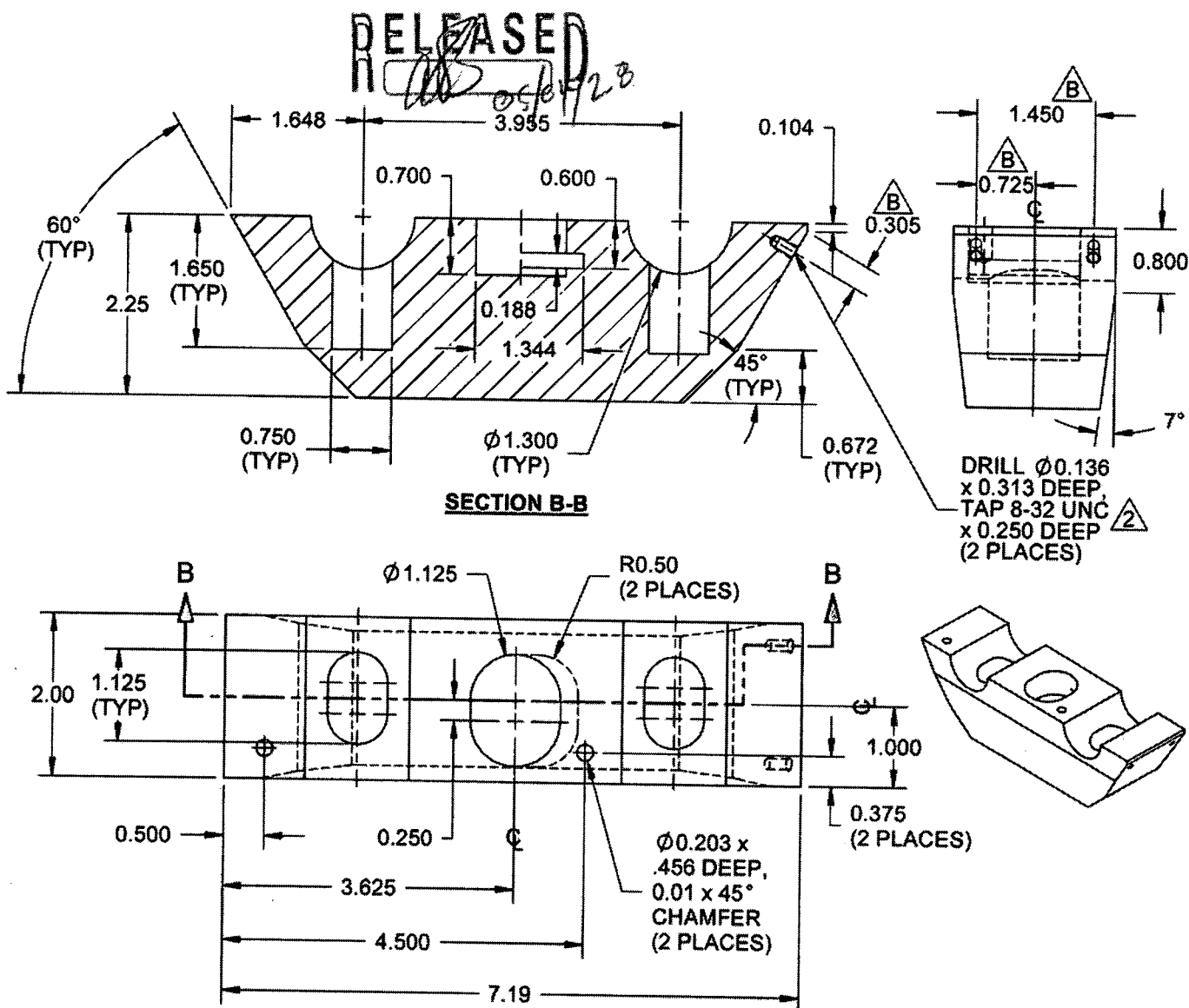
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B
DATE 05.03.22		TITLE PEDAL LOCK	SHEET 2 OF 4
			SCALE 1:2

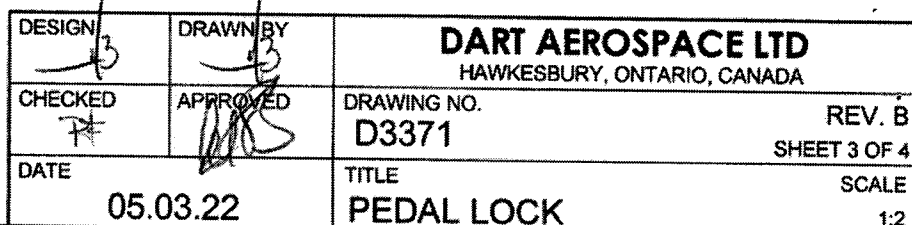


NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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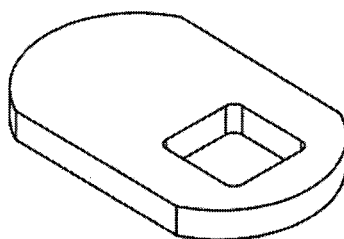
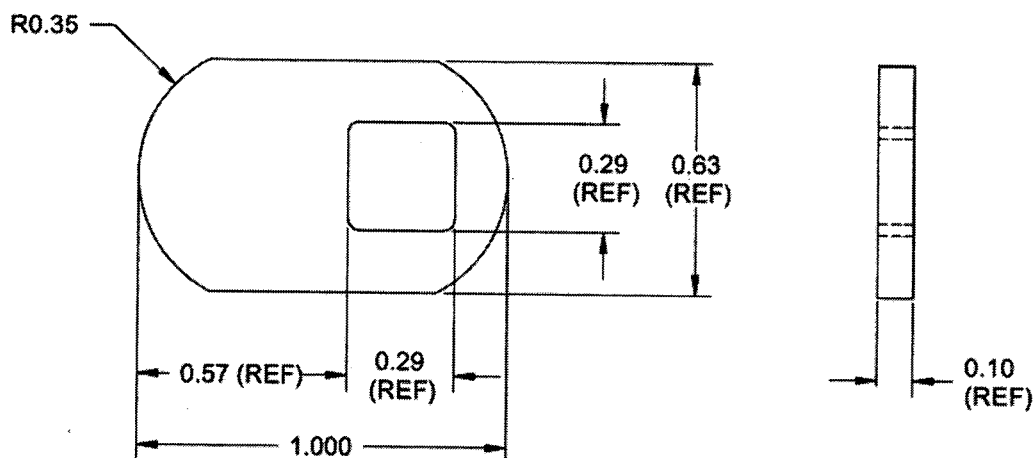
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/22

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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